

W/O SPLIT

rework

DART AEROSPACE LTD	Work Order:	23576
Description: Custom W/O to rework bracket	Part Number:	D3137-041
Dwg: D3137 Rev. D PAGE 2 of 2		1
Ref: N/A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	[Signature]	05.06.14	
2	ST	Remove from store. Qty Part Number Description Batch 1 D3331-041 Bracket Ass'y B18659	[Signature]	05.06.14	1
3	MV	Disassemble and cut to 0.250" in length at Ø0.560 as per dwg. Save MS24694 S101 screws in store with batch: M11735	[Signature]	05.06.15	1
4	QC5	Inspect work to Step 3.	[Signature]	05.06.15	1
5	MV	Assemble as per dwg. Qty Part Number Description Batch 1 MS24694-S98 Screw M16255	[Signature]	05.06.15	1
6	ST	Identify and Stock D3137-041.	[Signature]	05.06.15	1
7	AC	Charge to project number P602-2250 Cost / part: 24.12	[Signature]	05.06.17	1
8	DC	Close W/O 24.02 Inspect Level 21	[Signature]	05.06.20	1
(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)					

Rev	Date	Change	Revised By	Approved
A	05.06.14	New Issue	KJ/RF	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3137	REV. D SHEET 1 OF 4
DATE 04.11.03		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	

RELEASED
04.11.23

05.06.14

598

MS24694-S104 SCREW

D3137-5 WASHER

D3137-3 GUIDE

INSTALL ON SAME SIDE AS C'SINKS
(OPPOSITE SIDE FROM RIDGES)

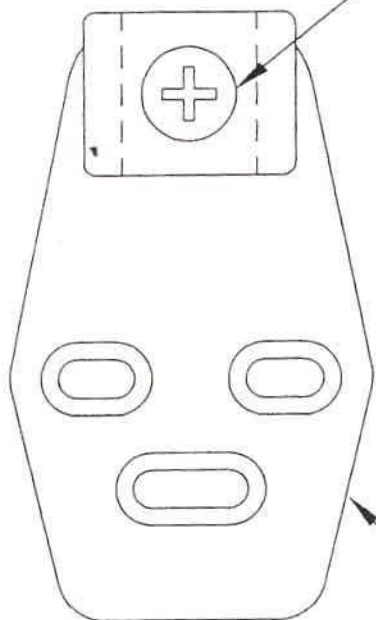
SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23576



D3137-1 BRACKET (-041 SHOWN)
OR

D3137-7 BRACKET (-043 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)

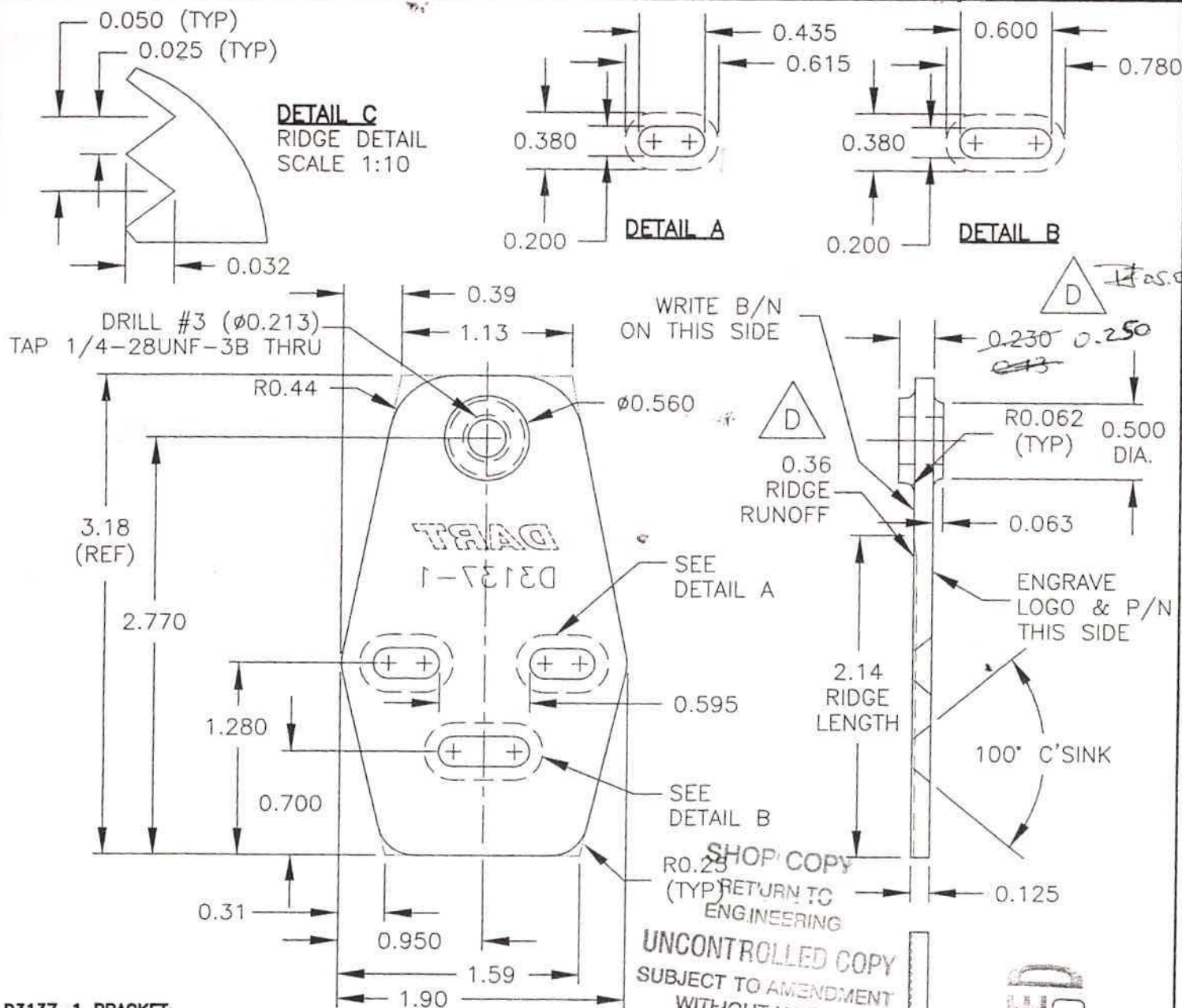
D3137-043 BRACKET ASSEMBLY (SIMILAR)

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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. D SHEET 2 OF 4
DATE 04.11.03		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3137-1 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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